

Date: Tuesday, 1/31/2006 11:03:17 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : GHW MEDIUM BELL
Job Number : 25682	
Estimate Number : 12129	
P.O. Number : N/A	Part Number : D412729041
This Issue : 1/31/2006 S.O. No. : N/A	Drawing Number : DSK 092 REV B
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : LARGE FAB ASSY	Drawing Revision : B
Previous Run : 25681	Material : N/A
Written By : SEE COMMENT BELOW	Due Date : 2/28/2006 Qty: 1 Um: Each
Checked & Approved By : [Signature] 06.01.31	
Comment : Est Rev:E 05.04.13 LPS3 rust inhibitor added; Hardware P/N's changed KJ/JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D27287	Decal
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2728-7 Label 322554

CPL 06.02.09

2.0	D3233041	Wheel Assembly
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D3233-041 Wheel Assembly 323577C

CPL 06.02.09

3.0	D32331	Inside Washer
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D3233-1 Inside Washer 323040

CPL 06.02.09

4.0	D32333	Outside Washer
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D3233-3 Outside Washer 323041

CPL 06.02.09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: GHW MEDIUM BELL

Job Number: 25682

Part Number: D412729041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D33091

Label



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3309-1 Label B22109

CPL 06.02.13

6.0

D33093

Label



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3309-3 Label B23768

CPL 06.02.13

7.0

D3330041

Frame Weldment



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3330-041 Frame Weldment B23016C B25637

8.0

D3331041

Handle Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3331-041 Handle Assembly B23568 B23769B

CPL 06.02.09

9.0

D3332041

Pin Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3332-041 Long Pin Assembly B23018 B23770

CPL 06.02.09

Dart Aerospace Ltd

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Part Number: D412729041

Job Number:



Seq. #:

Machine Or Operation:

Description :

10.0

D3332043

Pin Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3332-043 Short Pin Assembly

B23019 B23771

CPL 06.02.09

11.0

D33331

Base Plate Panel



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3333-1 Base Plate

B23055

CPL 06.02.09

12.0

D33333

Sliding Plate



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3333-1 Base Plate

B25684

CPL 06.02.23

13.0

D33335

Rail



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick:

Qty Part Number Description Batch

4 D3333-5 Rail

B23056

CPL 06.02.09

14.0

D33341

Wheel Shaft



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D3334-1 Wheel Shaft

B25686 B23022B

CPL 06.02.10

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Job Number:



Seq. #:

Machine Or Operation:

Description :

15.0

D33351

Short Spring



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3335-1 Short Spring B22256

CPL 06.02.09

16.0

D33353

Long Spring



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3335-3 Long Spring B22256

CPL 06.02.09

17.0

D33361

Inventory



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3336-1 Jack B23772A

CPL 06.02.10

18.0

AN960JD416

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 AN960JD416 Washer M18431

CPL 06.02.13

19.0

CP21

1/8" Cotter Pin 2" long



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 CP-21 1/8" Cotter Pin 2" long, Span M16301

CPL 06.02.13

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Job Number:



Seq. #:

Machine Or Operation:

Description :

20.0

HC12

1/4-20 UNC x 1" Hex Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 HC-12 1/4"-20 UNC x 1" long Hex Bolt, Span N/A

21.0

HC29

5/16-18 UNCX1.5 Hex Bolt



Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick:

Qty Part Number Description Batch

16 HC-29 5/16"-18 UNC x 1.5" long Hex Bolt, Prof M19705

CPL 06-02-13

22.0

HC153

3/8"-24UNFx1.25 Hex Bolt



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty Part Number Description Batch

8 HC-153 3/8"-24 UNF x 1.25" long Hex Bolt, Span M17356

CPL 06-02-10

23.0

HN120

HEX SLOTTED NUT



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 HN-120 1" Slotted Nut, Prof M18162

CPL 06-02-10

24.0

HN177

5/16-18UNC Nylon LockNut



Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick:

Qty Part Number Description Batch

16 HN-177 5/16"-18 UNC Nylon Lock Nut, Span M16626

CPL 06-02-13

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Job Number:



Seq. #: Machine Or Operation: Description :

25.0

HX15

1/4-20 UNCx3/4 S.H.C.S.



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 HX-15 1/4"-20 UNC x 3/4" long S.H.C.S., Span M16626

CPL 06.02.13

26.0

MS21042L5

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 MS21042L5 Nut (or -5) M169073

CPL 06.02.13

27.0

2333

1 1/4" Type B Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 2333 1 1/4" Type B Flat Washer (Wide), Span M16154

CPL 06.02.10

28.0

18SNB

3/8" Lock Washer



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty Part Number Description Batch

8 18-SNB3/8" Lock Washer, Span M19705

CPL 06.02.13

29.0

113803

1/8" PTF Grease Fitting



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

4 2 113-803 1/8" PTF Grease Fitting, Span M19705 M16533

CPL 06.02.13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ ☐ Date: 02/03/01

QA: N/C Closed: _____ Date: _____

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Job Number: 25682

Part Number: D412729041

Job Number:



Seq. #:

Machine Or Operation:

Description :

30.0

656036

Inventory



Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick:

Qty Part Number Description Batch

16 656-036 5/16" Type B Flat Washer (Narrow), Prof

17533
M19611

CPL 06.02.23

31.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Assemble as per Dwg DSK 092. Apply LPS3 heavy duty rust inhibitor & corrosion (Procyon). Inflate wheel assembly to 90 psi. Ensure that unit goes up and down smoothly after assembly. Install decals last.

CPL 06.02.27

32.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

33.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

CPL 06.02.28

①

Job Completion



Level 21 inspection

U 06.03.01

SD 06.03.01

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

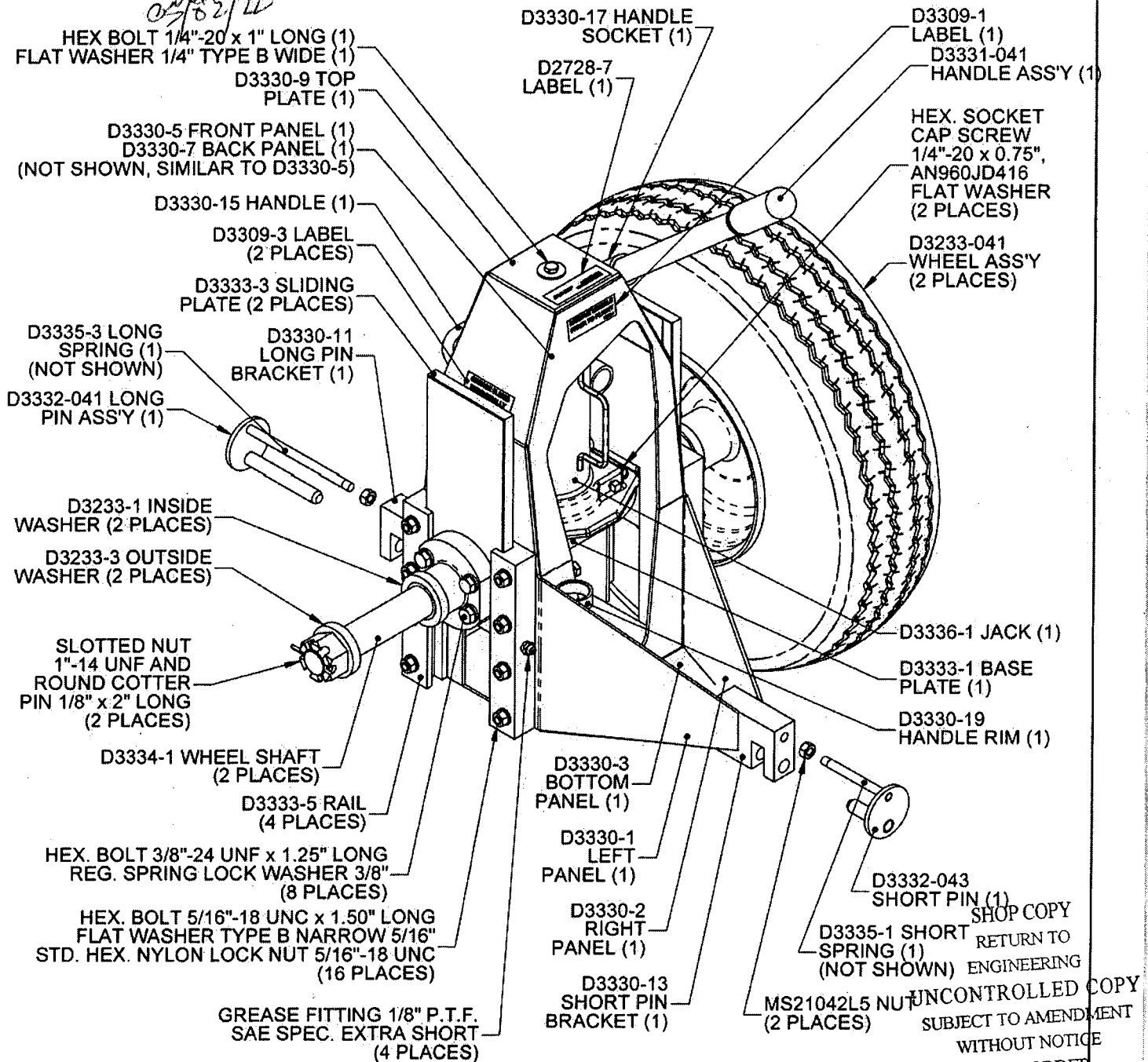
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DART

DESIGN ↓	DRAWN BY ↓	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED ↓	APPROVED ↓	DRAWING NO. DSK 092	REV. B SHEET 1 OF 1
DATE 05.02.18		TITLE HYD. GROUND HANDLING	SCALE 1:5
A	04.12.06	NEW ISSUE	
B	05.02.18	REDESIGN TO FIT NEW WHEEL ASS'Y	

RELEASED
07/02/22**NOTE:**

1) APPLY RUST INHIBITOR ON ALL PARTS AND AREAS NOT PROTECTED BY PAINT OR GREASE.
RUST INHIBITOR POSSIBLE SUPPLIER: ACKLANDS-GRANGER INC., P/N LPSC30316.

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 25682

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